IN THE ABSTRACT:

Please replace the existing Abstract with the following Abstract.

A laser machining apparatus capable of changing ~~a~~ laser output condition at a desired machining position and time without regard to ~~an~~ interpolation period (ITP). When the remaining motion command amount ~~Pa~~ in the former of successive blocks, used for the interpolation period Q0 between these blocks, is less than a motion command amount corresponding to a command speed in the ~~interpolation period~~ ITP, such deficiency ~~Pb~~ is supplemented by a motion command for the latter block, thus maintaining a moving speed unchanged. The laser output condition is changed between the blocks. ~~A time period t1 = ITP*Pa/(Pa+Pb) from when the interpolation period Q0 between the blocks starts to when a change from the former block to the latter is completed is determined.~~ In an ~~interpolation period~~ITP Q-1, a CNC sets the time period ~~t1~~ and the laser output condition in laser output control signal generating ~~means~~ unit which changes the laser output condition when the time period ~~t1~~ has elapsed from the start of the ~~interpolation period~~ITP Q0, making it possible to change the laser output condition at an arbitrary time without being limited by the ~~interpolation period~~ITP~~, whereby a highly accurate laser machining can be achieved~~.